

Date: Thursday, 2/9/2006 1:38:46 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)	
Job Number	: 25755C		Part Number	: D2221	
Estimate Number	: 10189		Drawing Number	: D2221 REV F	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/9/2006	S.O. No. : N/A	Drawing Revision	: F	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/28/2006	
Previous Run	: 25754A		Qty:	1 Um: Each	
Written By	: See comment below				
Checked & Approved By	: PD 06-02-10				
Comment	: Est. Rev:J 05.09.02 Added D3442-1KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31661	Basket Hoop		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D3166-1 RIB B25473 PD 06-02-27				
2.0	D22323	Basket Hinge		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-3 Hinge bracket B24527 PD 06-02-27				
3.0	D2325	Support Gusset (350 Bask)		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2325 Support Gusset B25687 PD 06-02-27				
4.0	D23273	Spacer Bushing		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2327-3 Bushing B24874 PD 06-02-27				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 25755C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket b25139

PD

06-02-27

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim b23544

PD

06-02-27

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 37.8000 sf(s)/Unit Total : 37.8000 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal M100071

PD

06-02-27

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M100133

PD

06-02-27

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:38:46 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 25755C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DL 06/03/02

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/04

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M19134

Expiry date: 06/06/20

SAD 06/03/07

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21



06/03/09

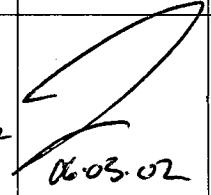
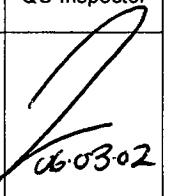
Job Completion



06/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes DQA:  Date: 06/03/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-02	10	The expanded metal strands are thinner near the bottom of the base: 5.5" up from the center, along 60° RH to LH, •072" thick.		Doesn't appear to be a severe strength issue. Inspect nests before installing, or cutting for the future. Basket is acceptable as is.	 06-03-02	 06-03-02	 06-03-02	 06-03-02

NOTE: Date & initial all entries



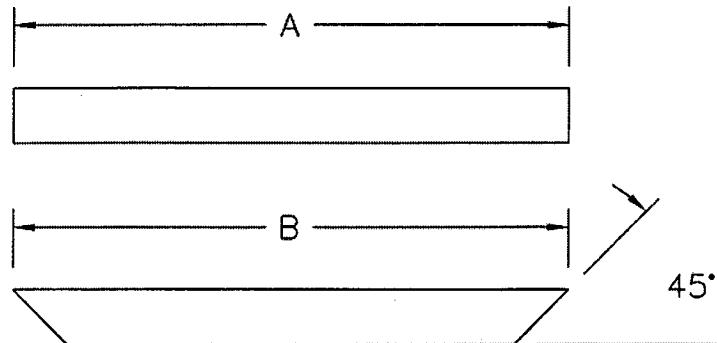
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

RELEASED

05.08.19 *[initials]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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RETURN TO

ENGINEERING

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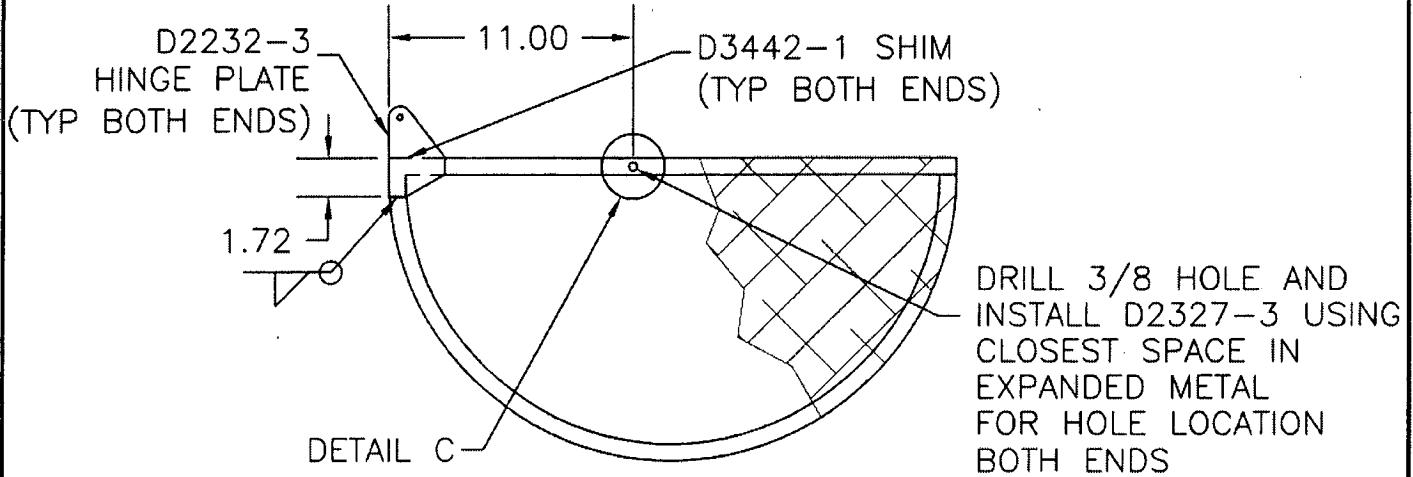
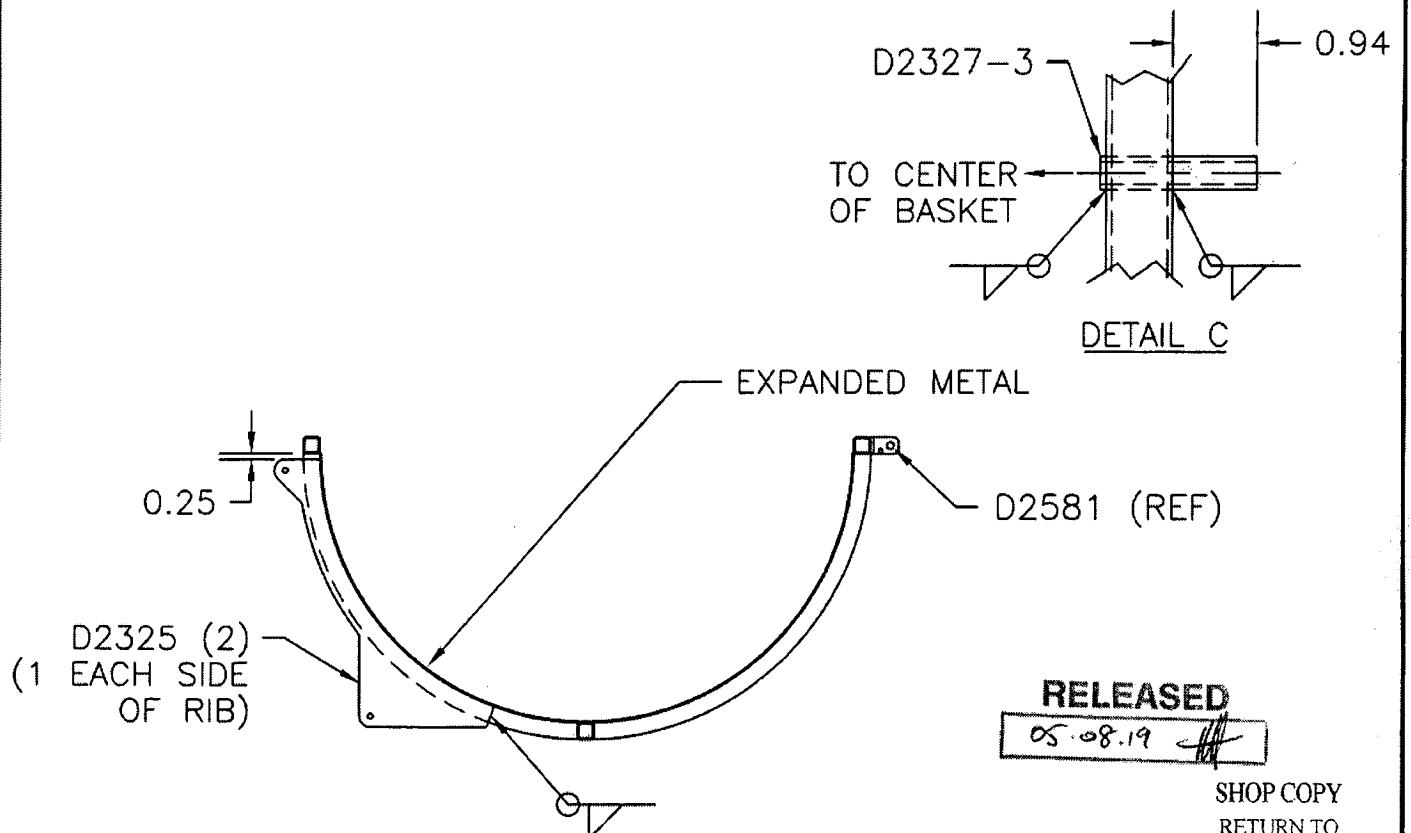
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WORK ORDER
NO. 25755C

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

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WITHOUT NOTICE

WORK ORDER

NO. *25755C*

SUBJECT TO AMENDMENT

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Date: Thursday, 2/9/2006 1:38:14 PM
 User: Kim Johnston

Process Sheet

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Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HELI UTILITY BASKET LH/RH 350/355		
Job Number	: 25755			Part Number	: D350607043		
Estimate Number	: 10208			Drawing Number	: D350-607 REV F P7-9		
P.O. Number	:			Project Number	: N/A		
This Issue	: 2/9/2006	S.O. No.	:	Drawing Revision	: F		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 2/28/2006	Qty:	1
Previous Run	: 25614			Um:	Each		
Written By	:						
Checked & Approved By	: <i>KJ</i> 06.02.10						
Comment	: Est Rev:E as Per DSI9318 06-01-24 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	25755A	BASKET LID ASSEMBLY 
2.0	25755B	BASKET LID ASSEMBLY 
3.0	25755C	BASKET BASE ASSEMBLY (350) 
4.0	DC	DOCUMENT CONTROL 
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
6.0	NAS1515H4	Washer 
Comment: Sub-Component BASKET LID ASSEMBLY Comment: Sub-Component BASKET LID ASSEMBLY Comment: Sub-Component BASKET BASE ASSEMBLY (350) Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD350-607-043 CHG003		
<i>KJ</i> <i>06.28.06</i>		
Comment: PACKAGING RESOURCE #1 Pick: Assemby Kit		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 NAS1515H4 WASHER _____		

REFERENCE ONLY